

Monday, 2/11/2008 2:13:46 PM  
Kim Johnston

Process Sheet

*SPLIT*

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-511
Job Number : 37360	
Estimate Number : 12893	
P.O. Number :	Part Number : K642 511
This Issue : 2/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11	Drawing Revision : N/A
Previous Run : 36021	Material :
Written By : <i>[Signature]</i>	Due Date : 2/28/2008
Checked & Approved By : <i>[Signature]</i>	Qty: <i>7</i> Um: Each
Comment : Est Rev.A 07.06.05 new issue EC Est Rev.B 08.02.05 , Per ECN1080P LL	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-511 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D206648013	GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

GHW Kit

Batch:

*B36026 x 6 B37365 x 1 B35599 x 1*

*AS 08/02/22*

4.0	D2652	Bushing
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Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D2652

Bushing

*37031*

*AS 08/02/22*

5.0	D2712	Set Screw
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

10 D2712

Set Screw

*B34628 x 10  
36186 x 70*

*AS 08/02/22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-1

Saddle

36874 x5 34783 x3

AS 08/02/22 (x8)

7.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-1

Saddle

34731 x5

AS 08/02/22 (x8)

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

1337368

AS 08/02/22 (x8)

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

30142

AS 08/02/22 (x8)

10.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

D2938-1

Saddle

B 34192 New Batch.

AS 08/03/13 (x8)

11.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-1

Saddle

36878

AS 08/02/22 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

356336

AS 08/02/22 (X8)

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

35510

AS 08/02/22 (X8)

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

33276

AS 08/02/22 (X8)

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B37123

AS 08/02/22 (X8)

16.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

~~AN3C35A~~ M106541

AS 08/02/22 (X8)

17.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M106541

AS 08/02/22 (X8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 37360

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

AN3C41A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M106176

AS 08/02/22 (x8)

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total: 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M106519

AS 08/02/22 (x8)

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M106552 x51 M107013 x13

AS 08/02/21 (x8)

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M106516

AS 08/02/21 (x8)

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104999 x1  
M106516 x31

AS 08/02/21 (x8)

23.0

AN5C15A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M105125

AS 08/02/21 (x8)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37360

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN5C32A



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105746

AS 08/02/21 (x8)

25.0

AN5C34A



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M105160

AS 08/02/21 (x8)

26.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

54 8/3/27

27.0

AN960C10L



washer

Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M107008

AS 08/02/21 (x8)

28.0

AN960C416L



WASHER

Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

~~M107008~~  
M105793 x 72  
~~M107008~~  
M107178 x 100  
M107008 x 20

AS 08/02/21 (x8)

Need's  
Big time  
fixing in computer  
SORRY my BAD  
AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37360

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description:

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

103344

AS 08/02/21 (x8)

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M107214 (13)

M107288 147  
8/3/21 50

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 104.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M106763 x13 M107101 x9B

AS 08/02/21 (x9)

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M105430

NO Batch in Comp.

x14

M107101 x18 AS 08/02/21 (x8)

33.0

D36721

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

PHENOLIC WASHER

B34470

AS 08/02/21 (x8)

34.0

D36723

PHENOLIC WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total: 192.0000 Each(s)

PHENOLIC WASHER

B34471

AS 08/02/21 (x8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 37360

Part Number: K642 511

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

PHENOLIC WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total: 128.0000 Each(s)

PHENOLIC WASHER

B35521

AS 08/02/20 (X8)

36.0

D36727

PHENOLIC WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 64.0000 Each(s)

PHENOLIC WASHER

B35522

AS 08/02/20 (X8)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/03/27 (F7)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-511 CHG003

Location: \_\_\_\_\_

8/3/27

(7X)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/27

Job Completion



MF

08-03-27

U

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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